Work Order II Tuesday, July 13, 2016		< CPA								Page 1
Revision ID:	2-664-207 tube Low Standard Aft		Accept				Setup	Start Stop		
Start Date: 7/13/20 Required Date: 8/3/20 Reference:	2010 Start Qty: 1.00			Cust Item ID: Customer:		/				
	cess Plan:	Date: 10-7-1-3	3 Tooling:	Date:]	Run	Start Stop		
		_ Date:	SPC (Y/N):	Date:		•				
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #		Accept Qty	Reje Qty		eject umber	Insp. Stamp
Draw Nbr	Revision Nbr					~	<u> </u>		unibei	Stamp
D212-664-247	Rev B		-							
00 	DOCUMENT CONTRO	DL	0.00							
Document Control	Memo Photocopy	bluefile and create labels as		CHG001						1
	Pick Kit Packaging		0.00			×				10-07
Packaging Packaging	Memo		0.00		-	- <i>(X</i> -	<u> </u>	¥)-	<u>u</u> s	10-07
	BENDING MACHINE	CROSSTUBES	0.00			h	6			
CNC Bend 2	Memo		0.00	•	-	Ø	(1	¥)-	MB	10.07
CNC Alpha 160 Bender	Bend tube a	s per Dwg D212-664-247 ս։	sing CNC bender progra	am and Folio						

W/O:			V					
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:	R	12-664-207 PAR #:	Fault Ca Disposit	itegory: x-fubes.	NCR: Yes N	lo DQA:	Date: 🚜	107/14
NCR: 60				DER NON-CONFORMAN				,
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
10.a.14	120 R:	Tube broke in the bender in the wrichle of the side bend.		Tobe is script> destreet. Tobe was LPT of in larose for reference i minor einer ferential cracks were fewer on the upper location of t	Um-		10-07-16	1008-14
	,							

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Tuesday, July 13, 2010 1:10:01 PM

Item ID:

D212-664-207

Accept

Setup Start

Revision ID:

Item Name:

Crosstube Low Standard Aft

Stop



Start Date:

7/13/2010

Required Date: 8/3/2010

Start Oty: 1.00 Reg'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date:

Tooling:

Date:

Tool # Plan

Code

Start

Run



QC: _____ Date:

SPC (Y/N):

Set Up/

Date:

Accept

Qty

Stop

Reject

Reject

Qty

Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC15- Crosstube Dimensional Check

Memo

Run Hours

0.00

0.00

140



Crosstubes Crosstubes

Crosstubes

0.00

Memo

0.00

1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.***Use T-Pin***

2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551

3-Ream hole to finish size in tube as per Dwg D212-664-247

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

5-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247



W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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				•								
Part No	Part No: PAR #: Resolution:		Fault Cate	NCR: Yes No DQA: Date:								
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NC	R)						
DATE	CTED	Description of NC		ction B	Verif	cation	Approval	Approval				
DATE	STEP	Section A	Initial Action Descrip Chief Eng Chief Eng		Sign Date	& Sec	tion C	Chief Eng	QC Inspector			
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Tuesday, July 13, 2010 1:10:01 PM



Page 3

Item ID:

D212-664-207

Accept



Tool # Plan

Code

Setup Start

Stop



Revision ID:

Item Name:

Crosstube Low Standard Aft

Start Date:

Required Date: 8/3/2010

7/13/2010

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

		Ш

Reference:

Approvals:

Process Plan: Date: Tooling:

_____ Date: _____

0.00

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Tool ID

Accept

Qty

Run

Stop

Qty

Start

Sequence ID/ Work Center ID

150

HandFXtube

Hand Finishing Crosstubes

Operation Description

Crosstubes Chemical Conversion

Memo

0.00

Chemical Conversion Coat Tube & Cuffs

160

QC

Quality Control

170

QC

Quality Control

QC3- Inspect Part Finish

Memo

QC5- Inspect part completeness to step on W/O

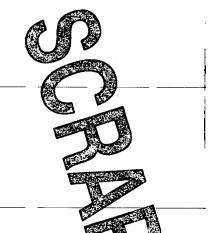
Memo

0.00

0.00

Reject Reject Number

Insp. Stamp



W/O:			WC	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Dort No.		DAD #-	Fault Oata		NOD: Vas	N- DO		Data	
Part No		PAR #:							
Resolution:							Date: _		
NCR:	NCR:		WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
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Tuesday, July 13, 2010 1:10:01 PM



Page 4

Item ID:

D212-664-207

Accept

Setup Start

Stop



Revision ID:

Item Name:

Crosstube Low Standard Aft

Start Date:

Required Date: 8/3/2010

7/13/2010

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

_____ Date: ____ SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date: _____

Date:

Tool # Plan

Code

Start Run



Stop

Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID**

180

Outsource2

Outsource process - NDT

190

Packaging

Packaging

200

Quality Control

Operation **Description**

Outsource process - NDT per QSI038 4.1

Memo

Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

Receive & Inspect for Damage & Mat'l Certs

QC5- Inspect part completeness to step on W/O

Packaging

Memo

0.00

0.00

Ensure copy of NDT results attached to work order.

0.00

0.00

Inspect for damage & ensure results are as per Dwg D212-664-207



Accept

Qty



W/O:			W	ORK ORDER CHANGES	3									
DATE	STEP	PRC	CEDURE CHA	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					

Part No:	.	PAR #:	PAR #: Fault Category: No				NCR: Yes No DQA: Date:							
	R	esolution: Disposition: Q			QA: N/C CI	osed:		Date: _						
NCR:	CR:			ER NON-CONFORMAN	CE (NCF	R)			40.00					
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DATE	CTED	Description of NC		Corrective Action Section		Verifi	cation	Approvai	Approval					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date		ication tion C	Approvai Chief Eng	Approval QC Inspector					
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approval Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approval Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approvai Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approval Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approval Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approval Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approval Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approvai Chief Eng						
DATE	STEP	Description of NC Section A		Action Description	Sign 8			Approvai Chief Eng						

Work Order ID Tuesday, July 13, 2010										Page 5
Item ID: D212-66 Revision ID: Item Name: Crosstub	54-207 e Low Standard Aft		Accept					•		
Start Date: 7/13/20 Required Date: 8/3/201 Reference:	10 Start Qty: 1.00			Cust Item I Customer:	D:				°P 	
Approvals: Proces	s Plan:	Date:	Tooling:	Da	nte:	-		Run Sta	art	
QC: _		Date:	SPC (Y/N):		ite:			St	ор	
Sequence ID/ Work Center ID 210	Operation Description Crosstubes		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Crosstubes	Memo		0.00						9	
Crosstubes	D212-664-2	assemble Cuffs with T-Pin 247. with Sika flex in Betwe AFLEX -241/-291 BATC	en tube & Cuff	s as per Dwg						i

0.00

0.00

215 QC

Quality Control

QC5- Inspect part completeness to step on W/O

Inspect cuff with T-Pin

Memo

111/0		WORK ORDER CHANGES										
W/O:			WC	PRK ORDER CHAN	IGES		· · · · · · · · · · · · · · · · · · ·					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:Resolution												
			n: Disposition: QA: N/C CI						Date: _			
NCR:		,	WORK ORDER NON-CONFORMANC)					
DATE	STEP	Description of NC		Corrective Action Section B			Sign & Verification			Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Date				Chief Eng	QC Inspector		
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Page 6

Item ID:

D212-664-207

Accept

Setup Start

Stop

Start



Revision ID:

Item Name:

Crosstube Low Standard Aft

Start Date:

7/13/2010

Start Qty: 1.00

Rea'd Otv: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:	

Required Date: 8/3/2010

Process Plan: Date: Tooling:

Set Up/

Run Hours

Date:

Date:

Stop

Run



OC:

Date:

SPC (Y/N):

0.00

0.00

Tool ID

Tool # Plan

Code

Accept

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID

220



SprayPaint

Spray Painting

Operation Description

Spray Painting per QSI005 4.2

SprayPaint

Memo

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time:

Fininsh Time:

PAINT:

Start Time:

Finish Time:

230



Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Wrap in plastic bag to protect from scratches



W/O:			WC	RK ORDER CHANG	ES			·····
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	0.00							
						•		
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
Resolution:		Disposition	1:	_ QA: N/C Cld	sed:	Date: _		
NCR:			WORK ORDER NON-CONFORM					
DATE	STEP	Description of NC	ļ <u>.</u>	Corrective Action Section E Initial Action Description		Verification		Approval
		Section A	Chief Eng	Chief Eng	Sign & Date	Section 6	Chief Eng	QC Inspector
}					!			
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Page 7

Item ID:

D212-664-207

Accept

Setup Start

Stop



Revision ID:

Item Name:

Crosstube Low Standard Aft

Start Date:

Required Date: 8/3/2010

7/13/2010

Start Qty: 1.00

Req'd Qty: 1.00



Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Tooling: SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/ **Work Center ID**

240

Crosstubes Crosstubes

Description

Operation

Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept Reject

Run

Reject

Insp.

Crosstubes

QC:

Memo

0.00

0.00

1- Assemble as per Dwg D212-664-247

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Instal support with magnobond 6398 per dwg D212-664-247, cure for 12hrs before packaging.

Time & date of application: Batch:

EXP. DATE

Memo

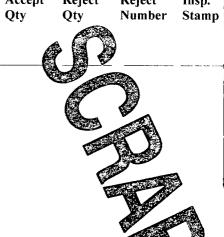
250

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00



W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHANGE			D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:PAR #:		PAR #:	Fault Category: NC			NCR: Yes No DQA: Date:						
		Disposition	:	QA: N/C	Close	d:	·	Date:				
NCR:		,	WORK ORDE	R NON-CONFORM	IANCE (NO	CR)						
DATE	STEP	Description of NC	Description of NC Corrective Acti			verii			Approval	Approval		
	0.1.	Section A	Initial Chief Eng	Action Description Chief Eng	Da		Sectio	n C	Chief Eng	QC Inspector		

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Page 8

Item ID:

D212-664-207

Accept

Setup Start



Revision ID:

Item Name:

Crosstube Low Standard Aft

Stop



Start Date:

Required Date: 8/3/2010

7/13/2010

Start Qty: 1.00 Req'd Qty: 1.00 **Cust Item ID:**

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	D:	ate:		R	tun Sta		
	QC:	Date:	SPC (Y/N):	Da	ate:		Stop			
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
255	Pick Kit		0.00							. !
Packaging Packaging	Memo		0.00							
260	QC4- 100% Inspect kits	for completeness	0.00							
QC Quality Control	Memo		0.00							
270 	Packaging		0.00							

Packaging Packaging

0.00

Memo

Identify and pack for shipping as per PPP D212-664-207

W/O:			ES						
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	<u> </u>	PAR #:	Fault Cat	egory:	NCR: Yes	No DO	 QA:	Date:	1
		esolution:							
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Corrective Action			Section B Verif			Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector
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Page 9

Item ID:

D212-664-207

Accept

Setup Start

Stop



Revision ID:

Item Name:

Crosstube Low Standard Aft

Start Date:

Required Date: 8/3/2010

7/13/2010

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Date: _____

Tooling:

SPC (Y/N):

Date: Date:

Run

Start



Stop

Sequence ID/

Work Center ID

280

QC

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Memo

0.00

0.00

mf 10-7-26



								
W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						:		
Part No	:	PAR #:			_ NCR: Yes I	No DQA:	Date: _	
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NCR:		V	VORK ORI	DER NON-CONFORMA	ANCE (NCR))		
DATE	OTED	Description of NC		Corrective Action Sect		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Tuesday, July 13, 2010 1:10:01 PM

Work Order ID: 60537

Parent Item:

D212-664-207

Parent Item Name: Crosstube Low Standard Aft



Start Date: 7/13/2010

Required Date: 8/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07.09.12 EC verified by: JLM

IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC IPP Rev:C ECN 1121 08-02-25 DD verified by:eC

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-207TRN	1111	Manufactured	No			110	Each	1.0000		1 8-506	88 N	NB la	g -07
				Location	!	Loc (<u>Oty</u>	Loc Code					
	-			LG	5/702		1		_			,	
3660-1 	i i i i i i i i i i i i i i i i i i i	Manufactured	No		56783	140	I Each	10.0000	2	2		0_ <i>G</i> A)
011				Location		Loc (<u> Oty</u>	Loc Code					
				ST477	53501		10 10		_		6		
R3212-4-06	 	Purchased	No			220	Each	1,441.000	44	44			
HERRY RIVÉT				Location		Loc (<u>Oty</u>	Loc Code			1		9
				ST311]	441				j	No. of House	

oc Qty	Loc Code
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156	
285	
200	
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	156 285 200

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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	R	esolution:	Disposition	QA: N/C C	osed:	Date: _			
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign 8	Sign & Section C		Approval Chief Eng	Approval QC Inspector
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Picklist Print

Tuesday, July 13, 2010-1:10:01 PM

Page 2

Work Order ID: 60537 Parent Item: D212-664-207 Parent Item Name: Crosstube Low Standard Aft Start Date: 7/13/2010 Required Date: 8/3/2010 Start Qty: 1.00 Required Qty: 1.00 D3595-063-530 Manufactured No 240 Each 109.0000 **RUBBER CUSHION** Location Loc Qty Loc Code FP 72 50030 12 51776 60 LG 37 59581 37 D2940-1 Manufactured No 240 Each 33.0000 Support Location Loc Oty Loc Code LG 33 45203 1 47748 12 57338 20 MS21920-28 Purchased No 240 Each 121.0000 Clamp(per MIL-DTL-8783C) **Location** Loc Qty Loc Code FG 5 105884 5 LG 116 112863 24 114749 92

Dail Aci	-cpace								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	
NCR:			VORK ORE	DER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC			ion B		cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date	* Sect	ion C	Chief Eng	QC Inspector
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Tuesday, July 13, 2010 1:10:01 PM

Work Order ID: 60537	-									
Parent Item: D212-66	64-207									
Parent Item Name: Cros	sstube Low Stan	dard Aft						tart Date: 7 Start Qty: 1		Required Date: 8/3/2010 Required Qty: 1.00
03428-1 		Manufactured	No		255	Each	8.0000	1	1	!
				Location ST056	33	Loc Qty 8 8	Loc Code			
MS21042L6		Purchased	No		255	Each	204.0000	6	6	
				Location ST300		Loc Oty 204 4	Loc Code			
	JAS1149D0663J	Purchased	No	1144	255	200 Each	0.0000	18	18	
NASHEI NAS-40A MMM MMM MMMM MMMMMMMMMMMMMMMMMMMMMMMM		Purchased	No		255	Each	75.0000	4	4	
				Location ST343 1128:	28	75 25 50	Loc Code			
N6-41 A 		Purchased	No		255	Each	56.0000	2	2	•
				Location ST344 11286 11328	05	56 6 50	Loc Code			

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W/O:			, W	ORK ORDER CHA	ANGES					<u> </u>
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes N	o DQA	.:	_ Date: _	
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NCR:		\	WORK ORI	DER NON-CONFO	RMANCE	(NCR)			,	
DATE	STEP	Description of NC Corrective Act			veri			ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion 	Sign & Date	Sectio		Chief Eng	QC Inspector
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Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		Х	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
. 4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	_44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6008-132

J FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART QSI 005 4.2
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
UNITS: INCHES UNLESS OTHERWISE NOTED.

TO WEIGHT: D212-664-247 = 36.6 bs (PER III) - 212-664)

D212-664-247B = 36.6 lbs (PER IIN-D212-664)

8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD

10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%

10) BEND PROJECTS VELT WITH A MINIMUM OF 6 PASSES. MAXIMUM TODE FOR TENING DOE TO BENDING START BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.

11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

12) INSTALL D2940-1 SUPPORT USING 0.03* TO 0.05* THICK LAYER OF MACROBOND 6398 TO THE SURFACE OF COURSE OF MACROBOND 6398. D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

INSTALLATION AND PROOF TO PACKAGING.

13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.

14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUPTO AS SCRATCHES, NICKS, OR DENTS.

DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.

SEAL EDGE OF CUFF TO ENSURE NO GAPS.

17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.



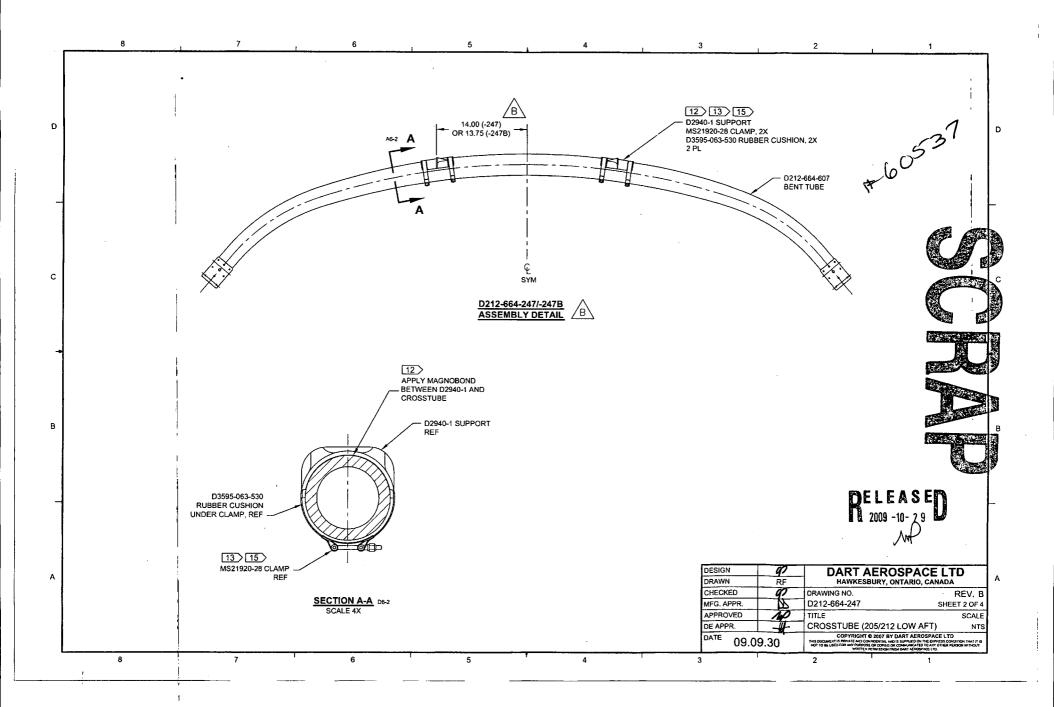


В			OTES/PART LIST; UPDATE TO RDS; ADD -247B (ZN C4-2, D5-2)	RF	09.09.30			
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REV.			DESCRIPTION	BY	DATE			
DESIGN		P	DART AEROSP	ACE	LTD			
DRAWN		RF	HAWKESBURY, ONTARIO, CANADA					
CHECKE	D	97	DRAWING NO.		REV. B			
MFG. AF	PR.	77	D212-664-247		SHEET 1 OF 4			
APPRO\	/ED	10	TITLE		SCALE			
DE APP	٦.		CROSSTUBE (205/212 LOV	VAFT)	NTS			
DATE	09.0	9.30	COPYRIGHT © 2007 BY DART A THIS DOCUMENT IS PROVIDE AND COMPOSITION, AND IS SUPPLIE NOT TO BE USED FOR ANY PURPOSE OR COMPANY WHETTEN PERMISSION FROM DART A	DON THE EXPR	ESS CONCIDION THAT IT IS			

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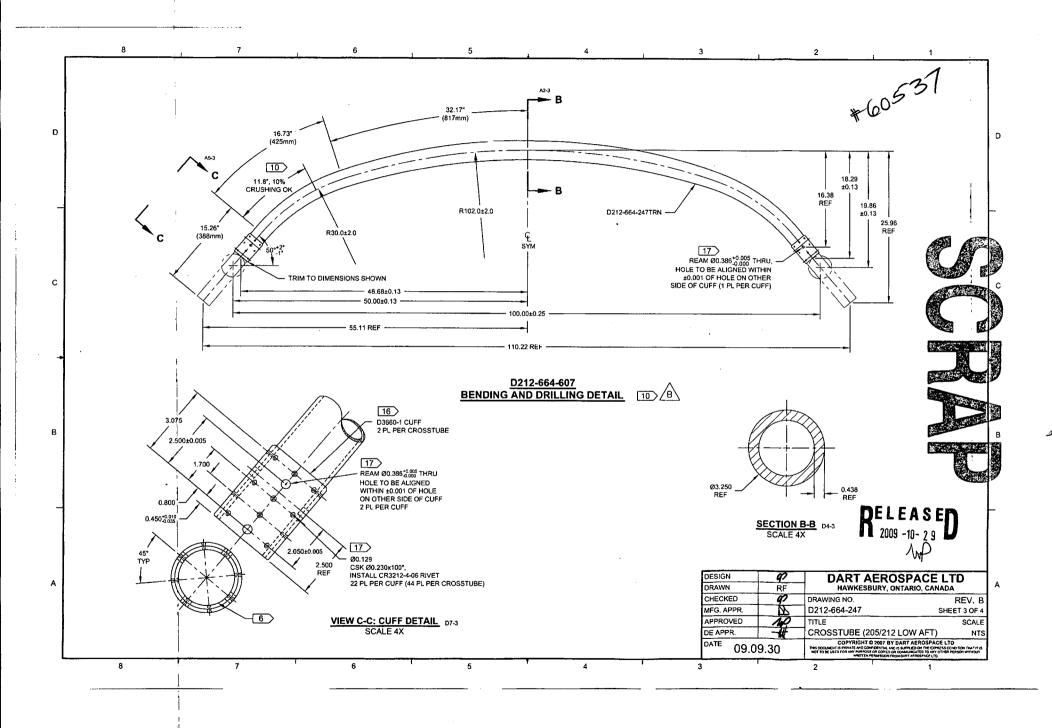
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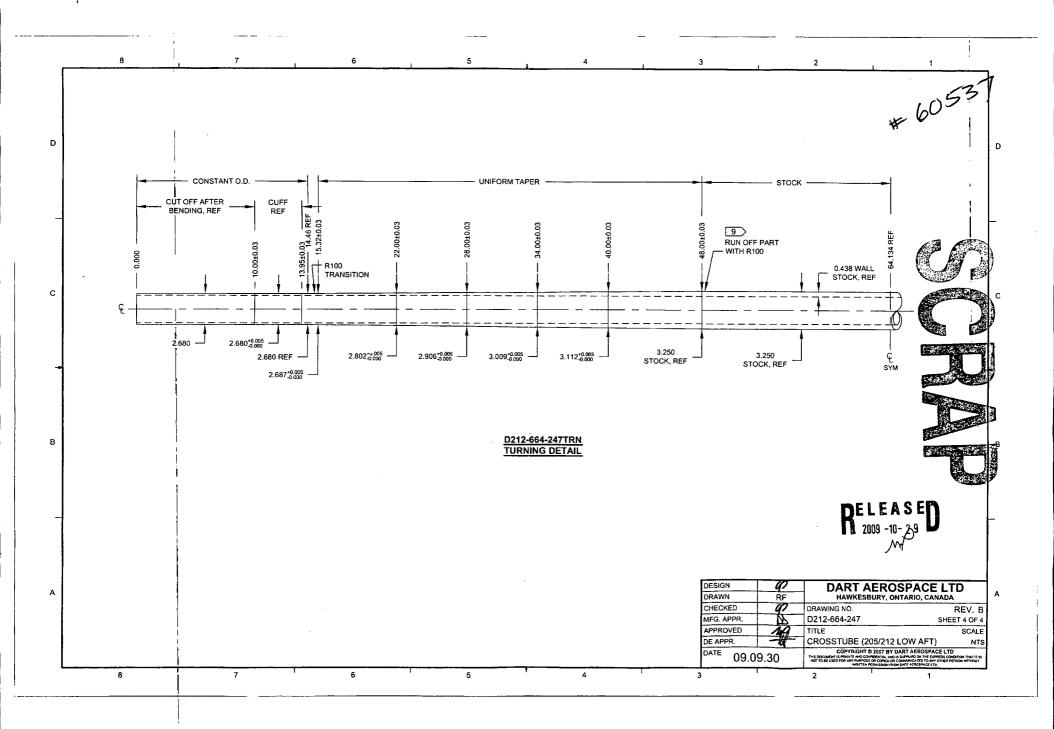
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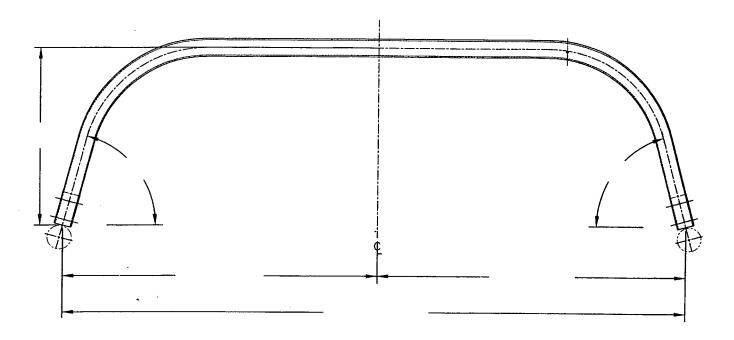
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DART AEROSPACE LTD	Work Order:	60537
Description: Crosstube Low Aft (205/212)	Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62





QC15 Inspection	
Date	

Rev	<u>Date</u>	Change	Revised by	Approved
Α	08.02.29	New Issue	KJ/JM	
В	10.04.01	Dwg Rev updated	KJ	

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